

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003075**Date Inspected:** 16-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	Wu Ming Kai			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower / OBG		

**Summary of Items Observed:****Bay 3**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 3 it was noted that ZPMC was in process for fit-up at multiple stages on side and bottom plates. ZPMC Certified Welding Inspector Wu Ming Kai and Xu Xian Ping was present at the time of observation and this QA inspector spoke with Mr. Kai on the work in process for bay 3. It was stated that tack welding for side, bottom and edge plates were in different stages of fit up. Shielded Metal Arc Welding (SMAW) was observed for the following locations by ZPMC, component numbers DP022-001, DP047-001 and DP024-001 ZPMC welders were Zhang Feng and Yang Gencheng. At gantry 2 for this bay ZPMC was in the process of welding fillet welds on DP055-001 were ZPMC had 2 welders at this location for the gantry. CWI Wu Ming Kai was monitoring the welding parameters and in process welding throughout this bay assisted by ZPMC Quality Control personnel.

**Bay 8**

This QA inspector continued his observation in bay 8 as ZPMC was using the Submerged Arc Welding (SAW) process for diaphragm plate number ESD1-SA301-11/12AB under WPS-B-T-3221-B-U3c-S-1 with welding operator for this location was Xu PeiPei for the Complete Joint Penetration splice for the diaphragm plate. There are multiple diaphragm plates in this bay at different stages of fabrication this day there approximately 33 diaphragm plates. ZPMC CWI Lv LiQing was observed being present at this location to monitor the welding parameters and progression and assisted by ZPMC Quality Control personnel.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As Noted Above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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